

NCR-19-7565



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3512-3

Job Sheet 201580



Part No: D3512-3

Part Name: Spacer



Part Weight: 0 lbs

Job Created: 10/7/19

Due Date: 10/31/19

Type: SOLD

Job Qty: 15 pcs

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: URF DWG ~~D3512~~ REV.D IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM IPP REV:B 13.12.11 ECN13-619/
REV.D DWG DD VERF:JLM IPP REV:C 18.03.12 DWG REV.E12 DD VERF:JFS

Ship Via:

POSITIVE RECALL

EFFECTIVE File/Log AUTH SA1RELEASED D DATE 19.10.24

Priority: Medium

Bill of Materials

Job Routing

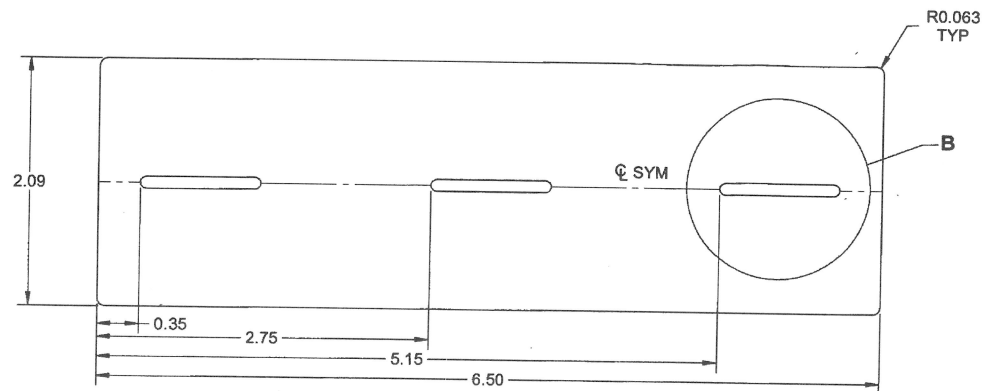
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	15		10/31/19	0.17	1.02	Waterjet - Flow		02/19/10/15
	CUT WITH DXF D3512-3 REV.E	15 pcs							
110	QC 2	15		10/31/19	0.00	0.00	QC 2 - 1		02/19/10/15
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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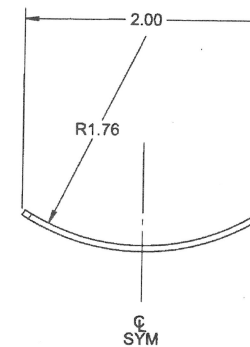
120	QC 8	15 pcs	10/31/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Small Fab - Brake NC - B4B	15 pcs	10/31/19	0.25 0.34	Small Fab - Brake - 1 - B4B	DAS 30 9-89 OCT 1 7 2019
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
140	QC 5	15 pcs	10/31/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
150	Packaging 3-1 - Stock - B4B	15 pcs	10/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	

				Packaging 3 - 4 - B4B					
				Packaging 3 - 5 - B4B					
				Packaging 3 - 6 - B4B					
				Packaging 3 - 7 - B4B					
				Packaging 3 - 8 - B4B					
				Packaging 3 - 9 - B4B					
				Packaging 3 - 10 - B4B					
				Packaging 3 - 11 - B4B					
				Packaging 3 - 12 - B4B	α				
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B					
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B					
				160 QC 21 - SA	15 pcs	10/31/19	0.00 0.00	QC 21 - SA - 21	
								QC 21 - SA - 70	
								QC 21 - SA - 53	
Part Op 100 - 1-Cut as per Dwg D3512 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Form as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Identify as per dwg & Stock Location: <u>W/O</u>), LOCATION: WA001-7 160 - (QC21- Final Inspection - Work Order Release)					DMC 21 9-30 OCT 25 2019				
Job BOM									
Part / Item	Component Name	Quantity	Operation	Container					
M304S18GA	304/316 .050 Sheet	1.4145 sf (.0943 ea)	100-Waterjet - Flow - 1	S159673 S204 S214648					
Job Allocations									
Operation	Component Part	Required	Inventory	Allocated					
100-Waterjet - Flow - 1	M304S18GA	1	131	0					
Part Specifications									
Specifications could not be found.									

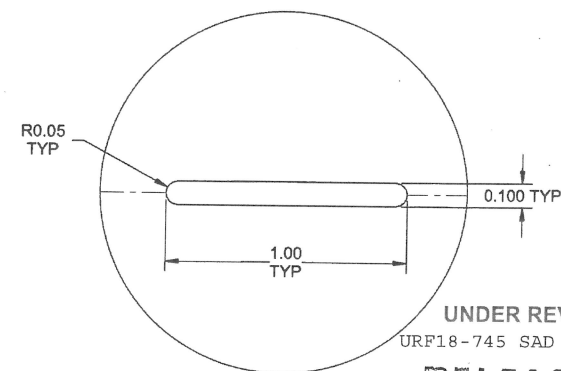
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D3512-3F FLAT PATTERN



D3512-3 SPACER
MAKE FROM D3512-3F



DETAIL B
SCALE 2X

UNDER REVIEW
URF18-745 SAD 18-06-19

RELEASED
2013-12-10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 18 GAUGE 0.050 THICK (REF DART SPEC. MS304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED		DRAWING NO. D3512	REV. D
MFG. APPR.		TITLE WEARPLATE ASSY	SHEET 4 OF 4
APPROVED			SCALE
DE APPR.			NTS
DATE	13.08.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

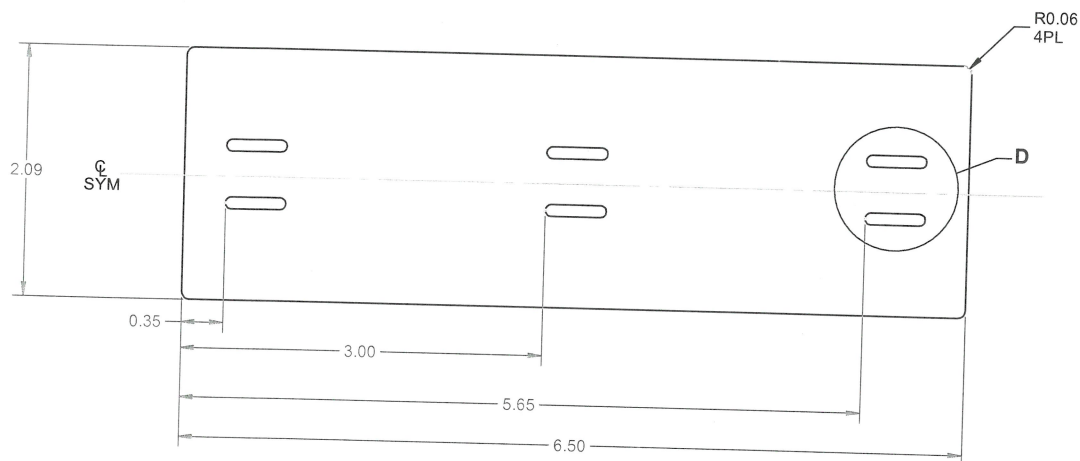
8 7 6 5 4 3 2 1

D

C

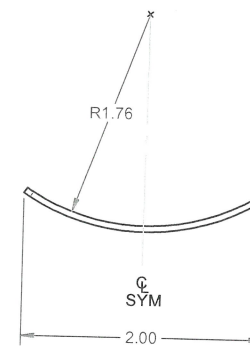
B

A

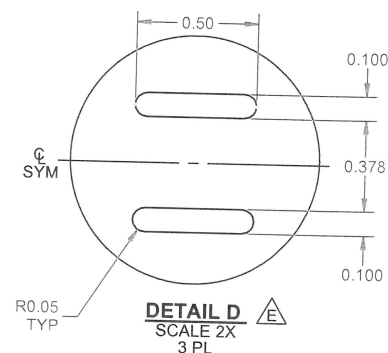


D3512-3F SPACER 
(FLAT PATTERN)

REFERENCE ONLY



D3512-3 SPACER
(MAKE FROM D3512-3F)



DETAIL D 
SCALE 2X
3 PL

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 18 GAUGE 0.050 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC.
DRAWN	SAD	HILLSBORO, OR
CHECKED	RF	DRAWING NO.
MFG. APPR.	DD	D3512
APPROVED		TITLE
DE APPR.		WEARPLATE ASSY
DATE	18.03.07	SCALE
		NTS

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Entered:

Date:

JK Oct 25/19



NCR No.

19-7565

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: <u>201580</u> Part No. <u>D3512-3</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier ☐ Quality ☐		
Date: <u>19-10-24</u>	Sequence #: <u>100</u>	QTY Affected: <u>22</u>	DAS 51 9-89 MRB (QS1042) <u>File 10/07</u>	
Description Work Order Deviation cut on waterjet D3512-3 DXF at Rev. E minor change to Rev. D flat pattern for manufacturability, No change to final bent wearplate Ref: 201450		Disposition Acceptable to cut D3512-3 DXF to Rev. E, It's to correct a minor fit issues from Rev. D Ref W/o 193591		Completed By <u>ac 19/10/24</u> Lead hand / Supervisor <u>PD 19-10-24</u> QC / QA Coordinator <u>PD 19-10-24</u>
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☒ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
Other/Details:				